

AMENDMENTS TO THE CLAIMS:

The following listing of claims replaces all prior listings, and all prior versions, of claims in the application.

LISTING OF CLAIMS:

1.-4. (Cancelled).

5. (Currently Amended) A hollow frame member according to claim ~~14~~19, wherein said corner portion is positioned at an extension line of a center in said thickness of said third plate.

6. (Currently Amended) A hollow frame member according to claim ~~14~~19, wherein said corner portion is positioned apart from a center line of thickness of said third plate.

7. (Cancelled)

8. (Previously Presented) A hollow frame member according to claim 15, wherein said second recessed portion is provided at a connection portion of said third plate and said one end of said second plate.

9. (Cancelled)

10. (Currently Amended) A hollow frame member according to claim ~~9~~16, wherein said second corner portion is positioned at an extension line of a center in said thickness of said third plate.

11. (Currently Amended) A hollow frame member according to claim ~~9~~16, wherein said second corner portion is positioned apart from a center line of said thickness of said third plate.

12.-14. (Cancelled)

15. (Currently Amended) A hollow frame member according to claim ~~43~~18, wherein:

at said one end of said ~~first~~second plate, a second recessed portion is provided in said second plate along to said one end of said second plate,

said second recessed portion opens directed toward an outer side in a thickness direction of said hollow frame member and said one end direction of said hollow frame member, and is defined by a further substantially vertical surface facing outwardly laterally to said thickness direction of said hollow frame member and by a further substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member,

said further substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member is positioned in a range, in the horizontal direction, ~~adjacent to~~ adjacent to thickness of said ~~hollow frame member~~ third plate,

said second recessed portion is a portion capable of having a friction stir welding carried out therein by inserting a rotary tool therein, and

in said friction stir welding, a center of said rotary tool is inserted into said hollow frame member and is substantially coincided with an extension line of said further substantially vertical surface facing outward laterally to said thickness direction of said hollow frame member.

16. (New) A hollow frame member adapted to be used in a friction stir welding, comprising:

a first plate, a second plate which is substantially in parallel to said first plate, a third plate for connecting one end of said first plate and one end of said second plate, said third plate being substantially perpendicular to said first plate and substantially perpendicular to said second plate and extending in a thickness direction of the hollow frame member, and a plurality of ribs arranged in a form of trusses to connect said first plate and said second plate,

at a side of an outer face of said one end of said first plate, a recessed portion is provided in said first plate along to said one end of said first plate,

said recessed portion opens directed to one outer side in said thickness direction of said hollow frame member and one end direction of said hollow frame member, and is defined by a substantially vertical surface facing outwardly in a horizontal direction, laterally to said thickness direction of said hollow frame member and by a substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member,

said substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member is positioned in a range, in said horizontal direction, of thickness of said third plate,

said recessed portion is a portion capable of having said friction stir welding carried out therein by inserting a rotary tool therein, and

in said friction stir welding, a center of said rotary tool is inserted into said hollow frame member and is substantially coincided with an extension line of said substantially vertical surface facing outwardly laterally to said thickness direction of said hollow frame member,

wherein said recessed portion is provided at a connection portion of said third plate and said one end of said first plate, and

wherein a first corner portion from said first plate to said recessed portion is positioned in a range of an extension of said third plate,

and wherein:

at a side of an outer face of said one end of said second plate, a second recessed portion is provided in said second plate along to said one end of said second plate,

said second recessed portion opens directed to one outer side in a thickness direction of said hollow frame member and one end direction of said hollow frame member, and is defined by a further substantially vertical surface facing outwardly in said horizontal direction, laterally to said thickness direction of said hollow frame member, and by a further substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member,

said further substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member is positioned in a range, in the horizontal direction, of thickness of said third plate,

said second recessed portion is a portion capable of having said friction stir welding carried out therein by inserting a rotary tool therein, and

in said friction stir welding, a center of said rotary tool is inserted into said hollow frame member and is substantially coincided with an extension line of said further substantially vertical surface facing outwardly laterally to said thickness direction of said hollow frame member,

wherein said second recessed portion is provided at a connection portion of said third plate and said one end of said second plate,

wherein a second corner portion from said second plate to said second recessed portion is positioned in said range of said extension of said third plate,

wherein said third plate sustains a vertical force produced by said rotary tool during said friction stir welding, and

wherein a raised portion is protruded from said first plate outside toward a side of said rotary tool and is plasticized by said rotary tool during said friction stir welding.

17. (New) A member adapted to be used in a friction stir welding, comprising:
a first plate, a second plate which is substantially in parallel to said first plate, a third plate for connecting one end of said first plate and one end of said second plate, said third plate being substantially perpendicular to said first plate and substantially perpendicular to said second plate, and a plurality of ribs arranged in a form of trusses to connect said first plate and said second plate,

in one end of said member, in one outer face in a thickness direction of said member and another outer face in said thickness direction of said member, recessed portions are provided respectively,

said recessed portion of said one outer face opens directed to one outer side in said thickness direction of said member and one end direction of said member, and is defined by one substantially vertical surface facing outwardly in a horizontal direction, laterally to said thickness direction of said member, and by one substantially horizontal surface facing outwardly in said thickness direction of said member,

said recessed portion of said one outer face is provided at a connection portion of said third plate and said one end of said first plate,

a corner portion from said first plate to said recessed portion is positioned in a range of an extension of said third plate,

said recessed portion of said another outer face opens directed to another outer side in said thickness direction of said member and one end direction of said member, and is defined by another substantially vertical surface facing outwardly in said horizontal direction, laterally to said thickness direction of said member, and by another substantially horizontal surface facing outwardly in said thickness direction of said member,

said recessed portion of said another outer face is provided at a connection portion of said third plate and said one end of said second plate,

a corner portion from said second plate to said recessed portion is positioned in said range of said extension of said third plate,

said one substantially horizontal surface facing outwardly in said thickness direction of said member is positioned in a range, in said horizontal direction, of thickness of said third plate,

said another substantially horizontal surface facing outwardly in said thickness direction of said member is positioned in said range, in said horizontal direction, of said thickness of said third plate,

said respective recessed portions are portions capable of having said friction stir welding carried out therein by inserting a rotary tool therein,

in said friction stir welding, a center of said rotary tool is inserted into said member and is substantially coincided with an extension line of said one substantially vertical surface facing outwardly laterally to said thickness direction of said member, and

in said friction stir welding, said center of said rotary tool is inserted into said member and is substantially coincided with an extension line of said another substantially vertical surface facing outwardly laterally to said thickness direction of said member,

wherein said third plate sustains a vertical force produced by said rotary tool during said friction stir welding,

wherein a first raised portion is protruded from said first plate outside toward a side of said rotary tool and is plasticized by said rotary tool during said friction stir welding, and

wherein a second raised portion is protruded from said second plate outside toward said side of said rotary tool and is plasticized by said rotary tool during said friction stir welding.

18. (New) A hollow frame member adapted to be used in a friction stir welding, comprising:

a first plate, a second plate which is substantially in parallel to said first plate, a third plate for connecting one end of said first plate and one end of said second plate, said third plate being substantially perpendicular to said first plate and substantially perpendicular to said second plate and extending in a thickness direction of the hollow frame member, and a plurality of ribs arranged in a form of trusses to connect said first plate and said second plate,

at a side of an outer face of said one end of said first plate, a recessed portion is provided in said first plate along to said one end of said first plate,

said recessed portion opens directed to one outer side in said thickness direction of said hollow frame member and one end direction of said hollow frame

member, and is defined by a substantially vertical surface facing outwardly in a horizontal direction, laterally to said thickness direction of said hollow frame member, and by a substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member,

said substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member is positioned in a range, in the horizontal direction, of thickness of said third plate,

said recessed portion is a portion capable of having said friction stir welding carried out therein by inserting a rotary tool therein, and

in said friction stir welding, a center of said rotary tool is inserted into said hollow frame member and is substantially coincided with an extension line of said substantially vertical surface facing outwardly laterally to said thickness direction of said hollow frame member,

wherein said third plate sustains a vertical force produced by said rotary tool during said friction stir welding, and

a raised portion is protruded from said first plate outside toward a side of said rotary tool and is plasticized by said rotary tool during said friction stir welding.

19. (New) A hollow frame member adapted to be used in a friction stir welding, comprising:

a first plate, a second plate which is substantially in parallel to said first plate, a third plate for connecting one end of said first plate and one end of said second plate, said third plate being substantially perpendicular to said first plate and substantially perpendicular to said second plate and extending in a thickness

direction of the hollow frame member, and a plurality of ribs arranged in a form of trusses to connect said first plate and said second plate,

at a side of an outer face of said one end of said first plate, a recessed portion is provided in said first plate along to said one end of said first plate,

said recessed portion opens directed to one outer side in said thickness direction of said hollow frame member and one end direction of said hollow frame member, and is defined by a substantially vertical surface facing outwardly in a horizontal direction, laterally to said thickness direction of said hollow frame member, and by a substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member,

said substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member is positioned in a range, in the horizontal direction, of thickness of said third plate,

said recessed portion is a portion capable of having said friction stir welding carried out therein by inserting a rotary tool therein, and

in said friction stir welding, a center of said rotary tool is inserted into said hollow frame member and is substantially coincided with an extension line of said substantially vertical surface facing outwardly laterally to said thickness direction of said hollow frame member,

wherein said recessed portion is provided at a connection portion of said third plate and said one end of said first plate, and

wherein a corner portion from said first plate to said recessed portion is positioned in a range of an extension line in said thickness of said third plate, said third plate sustaining a vertical force produced by said rotary tool during said friction stir welding, and

wherein a raised portion is protruded from said first plate outside toward a side of said rotary tool and is plasticized by said rotary tool during said friction stir welding.

20. (New) A hollow frame member according to claim 16, wherein said substantially horizontal surface and said further substantially horizontal surface are positioned adjacent said third plate in the range, in the horizontal direction, of thickness of said third plate.

21. (New) A member according to claim 17, wherein said one substantially horizontal surface and said another substantially horizontal surface are positioned adjacent the third plate in the range, in the horizontal direction, of thickness of said third plate.

22. (New) A hollow frame member according to claim 18, wherein said substantially horizontal surface is positioned adjacent said third plate in the range, in the horizontal direction, of thickness of said third plate.

23. (New) A hollow frame member according to claim 19, wherein said substantially horizontal surface is positioned adjacent said third plate in the range, in the horizontal direction, of thickness of said third plate.

24. (New) A member according to claim 15, wherein said one substantially horizontal surface and said another substantially horizontal surface are positioned

adjacent the third plate in the range, in the horizontal direction, of thickness of said third plate.